

# Work Order ID 75862

**\*75862\***

Page 1

Friday, November 18, 2011 10:07:37 AM

Item ID: K10111 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Saddle, Skidtube 206  
 Start Date: 11/1/2011 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 12/9/2011 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: *P* Date: 11/18/11 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_  
 Run Start **\*NR1\***  
 Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
DSI 9583	A
K10111	B

100	DOCUMENT CONTROL	0.00							
<b>*100*</b>									
DC	<b>Memo</b>	0.00							
Document Control	Photocopy bluefile & type labels per PPP FOR D206-642-111 CHG007 FOR D206-642-113 CHG002	K10111 CHG003							

*Schulz* *MLJ 11-11-24* *(4)*

110	Pick Kit	0.00							
<b>*110*</b>									
Packaging	<b>Memo</b>	0.00							
Packaging									

*SP 11-11-22*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 75862

**\*75862\***

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Friday, November 18, 2011 10:07:37 AM

Item ID: K10111 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 12/9/2011 Req'd Qty: 4.00 **\*4\*** Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC4- 100% Inspect kits for completeness  Memo	0.00 0.00				(x4)			
130 <b>*130*</b> Packaging Packaging	Packaging  Memo Identify and pack for shipping as per PPP K10111 PPP D206-642-111 PPP D206-642-113 Location: _____ PPP rev: _____	0.00 0.00							
140 <b>*140*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							

PPP 75732  
75728 DMH

11/11/2011  
MF  
11-11-25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Friday, November 18, 2011 10:07:43 AM

**\*75862\***

**\*K10111\***

**Required Date:** 12/9/2011

**Required Qty: 4.00**

**Comments:** IPP: F01.11.08 Revised Step 5 and Added Inspection Level  
21SM IPP REV:G  
11.09.23 PER REV.B DD VERF:EC IPP REV:H 11.11.14  
AS PER DSI9583 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN5-10A *AN5-10A* Bolt		Purchased	No				Each	872.0000	16	16			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST337			872						
				116704			11						
				118191			59						
				119547			802						
AN5-11A *AN5-11A* Bolt		Purchased	No				Each	1,599.000	16	16			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST337			21						
				117313			2						
				118191			19						
				ST518			1578						
				119512			1578						
AN3-41A *AN3-41A* Bolt		Purchased	No			110	Each	1,655.000	32	32			
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				st510			1655						
				119042			1655						

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Friday, November 18, 2011 10:07:43 AM

Work Order ID: 75862

\*75862\*

Parent Item: K10111

\*K10111\*

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

AN4-6A  
\*AN4-6A\*

Bolt

Purchased No

110 Each

5,062.000

12 48

\*\*

SP

Location

Loc Qty

Loc Code

ST356

62

119127

62

ST516

5000

119017

5000

110 Each

489.0000

\*\*

48X

SP

AN4C5A  
\*AN4C5A\*

BOLT

Purchased No

Location

Loc Qty

Loc Code

FP-B

49

112243

49

ST355

440

112243

340

119017

100

110 Each

511.0000

\*\*

4X

SP 11-11-23

AN6-44A  
\*AN6-44A\*

Bolt

Purchased No

Location

Loc Qty

Loc Code

ST343

7

119127

7

st510

504

119036

504

110 Each

1.0000

\*\*

8X

B SP 11-11-24  
B 75480

D206-651-041  
\*D206-651-041\*

206A/B GHW

Manufactured No

Location

Loc Qty

Loc Code

FG125

1

74002

1

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries



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Friday, November 18, 2011 10:07:43 AM

Work Order ID: 75862

**\*75862\***

Parent Item: K10111

**\*K10111\***

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

D2652

Manufactured No

110

Each

743.0000

16 64

\*\*

**\*D2652\***

Bushing

Location

Loc Qty

Loc Code

FG

44

31985

44

ST019

699

73835

579

73836

120

Manufactured No

110

Each

18.0000

2 8

\*\*

**\*D2661-1\***

Saddle, LH Fwd Aft Out 206

Location

Loc Qty

Loc Code

MEZZ

5

64559

5

ST435

13

73838

10

73841

1

76516

2

Manufactured No

110

Each

20.0000

2 8

\*\*

**\*D2662-1\***

Saddle, LH In 206

Location

Loc Qty

Loc Code

ST435

10

73846

1

74479

9

ST476

10

74481

10

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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# Picklist Print

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Friday, November 18, 2011 10:07:43 AM

Work Order ID: 75862

**\*75862\***

Parent Item: K10111

**\*K10111\***

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

S D2712  
**\*D2712\***  
Set Screw

Manufactured No

110 Each 2,551.000 10 40

\*\*

SP

Location	Loc Qty	Loc Code
FG	50	
29962	50	
ST021	2501	
71160	1	
73837	500	40x
76065	2000	

S D2884  
**\*D2884\***  
Saddle Spacer

Manufactured No

110 Each 100.0000 2 8

\*\*

SP

Location	Loc Qty	Loc Code
FG	10	
29453	10	
ST025	90	
73823	90	8x

Manufactured No

110 Each 126.0000 2 8

\*\*

SP 11-11-23

S D2885  
**\*D2885\***  
Saddle Spacer

Location	Loc Qty	Loc Code
FG	10	
29199	10	
ST025	116	
73824	116	8x

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Friday, November 18, 2011 10:07:43 AM

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Work Order ID: 75862

\*75862\*

Parent Item: K10111

\*K10111\*

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

D3413-1

Manufactured No

110

Each

94.0000

4

\*\*

\*D3413-1\*

Ring

Location

Loc Qty

Loc Code

ST368

2

73821

2

ST420

2

66387

1

70773

1

ST469

88

73822

88

ST473

2

71041

2

MS21042L3

Purchased No

110

Each

8,753.000

32

\*\*

\*MS21042L3\*

Nut

Location

Loc Qty

Loc Code

ST300

255

117441

16

117885

35

118451

5

118927

199

ST516

6000

119017

6000

ST518

2498

119075

2498

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Shop Packet Print

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Friday, November 18, 2011 10:07:43 AM

Work Order ID: 75862

**\*75862\***

Parent Item: K10111

**\*K10111\***

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

MS21042L4

Purchased

No

110

Each

11,450.00

12

48

\*\*

**\*MS21042I 4\***

Nut

Location

Loc Qty

Loc Code

ST300

558

117441

51

117601

374

118451

133

ST516

5892

119017

5892

ST518

5000

119075

5000

48x

MS21042L6

Purchased

No

110

Each

1,484.000

2

8

\*\*

**\*MS21042I 6\***

Nut

Location

Loc Qty

Loc Code

ST300

484

117677

25

118384

5

118927

48

118968

406

ST518

1000

119075

1000

8x

NAS1149C0463R

Purchased

No

110

Each

1,379.000

4

\*\*

**\*NAS1149C0463R\***

Washer

Location

Loc Qty

Loc Code

FP-B

1

115358

1

ST297

1378

117735

378

119097

1000

4x

80 11-11-23

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Friday, November 18, 2011 10:07:43 AM

Work Order ID: 75862

**\*75862\***

Parent Item: K10111

**\*K10111\***

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0363J

Purchased

No

110

Each

4,434.000

8

32

**\*NAS1149D0363.I\***

Washer

\*\*

SP

Location

Loc Qty

Loc Code

ST019

16

117505

16

ST295

3000

119537

3000

ST298

1418

117601

148

118077

1

118612

55

118968

1214

32x

NAS1149D0463J

Purchased

No

110

Each

12,582.00

24

96

**\*NAS1149D0463.I\***

Washer

\*\*

SP 11-11-23

Location

Loc Qty

Loc Code

ST019

25

118179

25

ST298

299

116025

16

116805

0

117291

1

117460

2

118179

17

118384

249

118612

3

119042

11

ST407

12258

119075

10000

119097

2258

96x

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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# Picklist Print

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Friday, November 18, 2011 10:07:43 AM

Work Order ID: 75862

**\*75862\***

Parent Item: K10111

**\*K10111\***

Parent Item Name: Saddle, Skidtube 206

Start Date: 11/1/2011

Required Date: 12/9/2011

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0563J

Purchased

No

110

Each

5,121.000

8 32

**\*NAS1149D0563.I\***

Washer

\*\*

SP

Location

Loc Qty

Loc Code

ST296

2000

119546

2000

ST298

3121

118206

2121

118614

1000

32.

NAS1149D0663J

Purchased

No

110

Each

2,598.000

4 16

**\*NAS1149D0663.I\***

Washer

\*\*

SP 11-11-23

Location

Loc Qty

Loc Code

ST407

2598

119075

2598

16x

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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REFERENCE ONLY

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING SKIDTUBE AND SADDLE INSTALLATIONS:

AIRCRAFT	INSTALLATION
BELL 206 A/B	D206-642-111
BELL 206 A/B	D206-642-113

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE FOLLOWING TABLE (REF):

ITEM	PART NUMBER	K10111	D206-642-111	D206-642-113
1	D206-651-041	1	1	1
2	D2652	16	16	16
3	D3413-1	1	1	1
4	D2661-1	2	2	2
5	D2662-1	2	2	2
6	D2712	10	10	10
7	D2884	2	2	2
8	D2885	2	2	2
9	AN3-41A	8	8	8
10	AN4C5A	1	1	1
11	AN4-6A	12	12	12
12	AN5-7A		8	
13	AN5-10A	4		4
14	AN5-11A	4		4
15	AN6-44A	2	2	2
16	NAS1149D0363J	8	8	8
17	NAS1149D0463J	24	24	24
18	NAS1149D0563J	8	8	8
19	NAS1149D0663J	4	4	4
20	MS21042-3 (OR L3)	8	8	8
21	MS21042-4 (OR L4)	12	12	12
22	MS21042-6 (OR L6)	2	2	2
23	NAS1149C0463R	1	1	1

C	ADDED ITEM COLUMN, ADDED ITEMS 13 & 14, QTY'S FOR ITEM 12 UPDATED.	AJS	11.11.10
B	ADD APPLICABILITY TO D206-642-113	AJS	11.09.19
A	NEW ISSUE	RF	00.05.17
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>140</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>BE</i>	K10111	SHEET 1 OF 1
APPROVED	<i>140</i>	TITLE	SCALE
DE APPR.	<i>140</i>	SADDLE KIT	NTS
DATE	11.11.10	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	